

# Work Order ID 64883

December 21, 2010 1:07:26 PM



Page 1

Item ID: D3197-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar Assembly

Start Date: 12/21/10 Start Qty: 2.00



Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-10-21

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr
D3197	Rev B

100



BAND SAW

Bandsaw

Memo

0.00

B.A 11/01/17

2 0

Jeaspa Bandsaw

Cut blanks: 29.125" long

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Face ends to lenght per dwg D3197-2-Machine D3197-1 as per Folio FA340  
and Dwg D3197-3-Deburr

2 1

PL →

120



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

S2 11/01/18

2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3197-041 PAR #: Fault Category: Machining NCR: Yes No DQA: Date: 11/01/20  
 Resolution: Scrap Disposition: scrap QA: N/C Closed: ✓ Date: 11/01/20

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/01/18	110	-1 part has center-drill mark where Ø.191 is -engine was not taken correctly "off center"	11.01.18	SCRAP + Replace Qty +1 m 116604	11/01/18	11/01/18	11.01.18 051042	11/01/18
		2-G - operation error						
		3-1771 scrap						

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



CONVENTIONAL LATHE

0.00

Lathe Conv

Conventional Lathe

Memo

Chamfer as per Dwg D3197

0.00

JL 11/01/18

2 0

140



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

B.A 11/01/18

2 0

150



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Hand Finishing

Memo

0.00

JL 11/01/18

2 0

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Setup

Start



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Item Name: Bar Assembly

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Start Date: 12/21/10 Start Qty: 2.00



Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

160



Powdercoat

Powder Coating

Operation  
Description

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

Memo

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

M

11/01/09

X2 0

Memo

0.00

180



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble D3197-041 as per Dwg D3197

*12/21/10 1:07:27 PM*

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Item ID: D3197-041

Accept



Setup Start



Revision ID:

Item Name: Bar Assembly

Stop



Start Date: 12/21/10 Start Qty: 2.00



Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Sulak

(42)

200



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 260

0.00

Memo

0.00

11/01/10 (2)

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/01/10 (2)

MF

11-01-29

## Picklist Print

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**Work Order ID:** 64883



**Parent Item:** D3197-041



**Parent Item Name:** Bar Assembly

**Start Date:** 12/21/10

**Required Date:** 12/30/10

**Comments:** IPP Rev: A New Issue 05-11-08 JLM  
IPP Rev:B As per Rev B 06-03-10 JLM

**Start Qty:** 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10 Washer	NAS1149D0363J	Purchased	No	471115622 (12x)		180	Each	8.0000	6	12	12	EJS 11/01/19	
D2690-5 Lanyard Assembly		Manufactured	No			180	Each	14.0000	2	4	4	EJS 11/01/19	
D3242-1 Tag		Manufactured	No			180	Each	2.0000	2	4	4	EJS 11/01/19	
D3489-3-200 PIP PIN		Manufactured	No			180	Each	2.0000	2	4	4	EJS 11/01/19	
												B65129 (3x)	

# Picklist Print

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Work Order ID: 64883



Parent Item: D3197-041



Parent Item Name: Bar Assembly

Start Date: 12/21/10

Required Date: 12/30/10

Start Qty: 2.00

Required Qty: 2.00

M7075T73R1.000

Purchased

No

180

f

8.6000

2.42

6.05



7075-T73 Rd Bar 1.00

B.A 11/01/17

116604

ft  
6.0500

Location

Loc Qty

Loc Code

MAT

8.6

115165

5

116405

3.6

MS21042L3

Purchased

No

180

Each

1,870.000

2



Nut

EJS 11/01/17

Location

Loc Qty

Loc Code

ST300

1870

114784

9

115835

957

116373

4

116391

900

MS27039-1-24

Purchased

No

100

Each

99.0000

2



Screw

EJS 11/01/17

Location

Loc Qty

Loc Code

ST292

99

100151

99

4

DART AEROSPACE LTD	Work Order:	64883
Description: Bar	Part Number:	D3197-1
Inspection Dwg: D3197	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

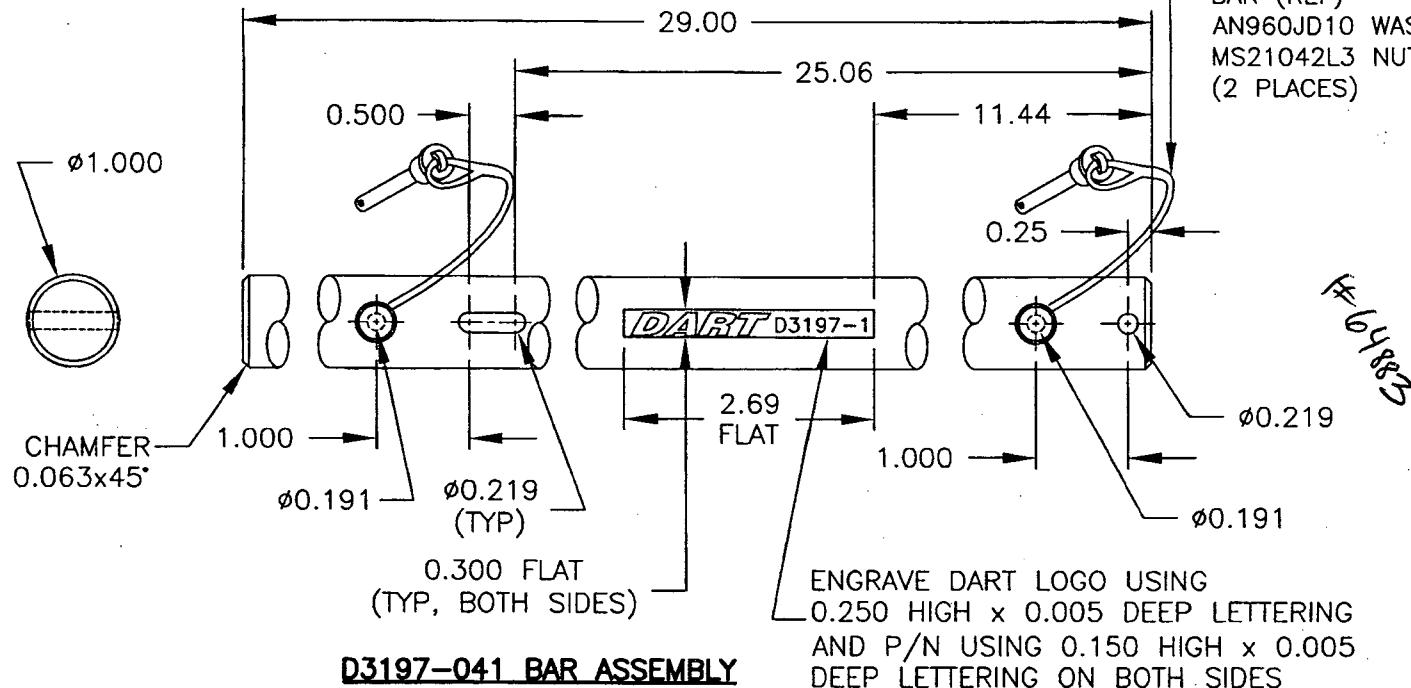
Measured by:	SL	Audited by:	h. A	Prototype Approval:	N/A
Date:	11/6/118	Date:	11/01/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3197-041)	KJ/JLM	
B	07.03.09	Dwg revision update	KJ/JLM	

RELEASED  
05-03-21  
per BEN TEC

**DART**

D3489-3-200 PIP PIN (1)  
D3242-1 TAG (1)  
MS27039-1-24 BOLT (1)  
AN960JD10 WASHER (1)  
D2690-5 LANYARD (1)  
AN960JD10 WASHER (1)  
BAR (REF)  
AN960JD10 WASHER (1)  
MS21042L3 NUT (1)  
(2 PLACES)



#### D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9)  $\varnothing 1.000$  O.D.  
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER  
END OF THE BAR

DESIGN		DRAWN BY	CP	DART AEROSPACE LTD	
CHECKED	APPROVED			HAWKESBURY, ONTARIO, CANADA	
		DRAWING NO.		REV. B	
		D3197			
DATE		06.01.10	MLE		
A		03.07.01	BAR		
B		06.01.10	CHG PIP PIN; ADD D3242-1 TAG		
				SHEET 1 OF 1	
				SCALE	1:1